

Work Order ID 129190

Friday, January 30, 2015 11:01:11 AM

129190

Page 1

Item ID: D139-816-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lightweight Interior Ceiling Panel
 Start Date: 1/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1501-30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9686	A								
DSI9691	A								
IIN-D139-816	D								

100 Document Control 0.00
1000 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy blue file & type labels as per PPP D139-816-011 CHG005
 1/006 see attachment
 MLJ
 DAS 27 9-89
 DEC 17 2015

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging
 DAS 28 9-89
 NOV 30 2015

DEC 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Revision ID: Stop ***NS2***
Item Name: Lightweight Interior Ceiling Panel
Start Date: 1/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D139-816-011 Identify and Stock								
	Location: FG 96								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SMB
25/12/17

DAS
28
9-89

DEC 17 2015

ML5

DEC 23 2015

SA 20151222

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

Picklist Print

Friday, January 30, 2015 11:01:16 AM

Page 1

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 12/05/07 New Release DL
IPP Rev. B 12/11/08 Update dwg. DL
Dwg. Update 13/07/09 DL verf:DD
PER IIN REV.D DD VERF:JFS
DSI9686 JLM VERIFIED BY:DD
IPP Rev. C
IPP REV:D 13.12.23 AS
IPP REV E 14.04.01 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4634-041		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4634-041									**				DAS 28 9-89
Fwd, Center Ceiling Panel Assembly													
D4634-043		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4634-043									**				DAS 28 9-89
Middle, Center Ceiling Panel Assembly													
D4634-045		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4634-045									**				DAS 28 9-89
Aft, Center Ceiling Panel Assembly													
D4635-041		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4635-041									**				DAS 28 9-89
Fwd Ceiling Panel Assembly, LH													
D4635-042		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4635-042									**				DAS 28 9-89
Fwd Ceiling Panel Assembly, RH													
D4635-043		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4635-043									**				DAS 28 9-89
Aft Ceiling Panel Assembly, LH													
D4635-044		Manufactured	No			110	Each	0.0000	1	1			DAS 28 9-89
D4635-044									**				DAS 28 9-89
Aft Ceiling Panel Assembly, RH													

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4636-043

Manufactured No

110 Each 42.0000 16 16

D4636-043

Receptacle Bracket Assembly

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST116

6

124109

6

ST119

36

126493

36

D4636-11

Manufactured No

110 Each 23.0000 10 10

D4636-11

Bracket

Location

Loc Qty

Loc Code

ST116

16

126494

16

ST119

7

125199

7

D4636-5

Manufactured No

110 Each 34.0000 16 16

D4636-5

Bracket

Location

Loc Qty

Loc Code

MF

5

124298

5

ST119

29

126495

29

D4636-7

Manufactured No

110 Each 12.0000 4 4

D4636-7

Retainer Plate

Location

Loc Qty

Loc Code

ST224

12

124519

12

DAS

6

9-89

DAS

28

9-89

DAS

27

9-89

DAS

6

9-89

DEC 02 2015

DAS

27

9-89

Friday, January 30, 2015 11:01:16 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 30, 2015 11:01:16 AM

Page 3

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4636-9 Manufactured No

110 Each 27.0000 1 1

D4636-9

Template

BAS
27
9-89

Location

Loc Qty

Loc Code

ST119

27

117653

1

124315

26

D4648-1 Manufactured No

110 Each 11.0000 1 1

D4648-1

Template

BAS
27
9-89

Location

Loc Qty

Loc Code

ST224A

11

117658

8

119840

3

D4653-041 Manufactured No

110 Each 7.0000 6 6

D4653-041

Vent Manifold Assembly

BAS
27
9-89

Location

Loc Qty

Loc Code

ST224A

7

125364

1

125365

6

D4653-11 Manufactured No

110 Each 20.0000 6 6

D4653-11

Clamp

BAS
27
9-89

Location

Loc Qty

Loc Code

ST224A

20

125405

8

127148

12

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Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4664-7 Manufactured No

110 Each

8.0000

3

3

D4664-7

Spacer

DAS
27
9-89

Location

Loc Qty

Loc Code

ST121

8

114887

8

**

~~129190~~

DAS

6

9-89

DAS

28

9-89

D4712-043

Manufactured No

110 Each

27.0000

2

2

D4712-043

Bracket Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

ST224A

27

125380

13

127232

14

**

~~114887~~

DAS
6
9-89

DAS

28

9-89

D4716-1

Manufactured No

110 Each

10.0000

2

2

D4716-1

Duct Hose

DAS
27
9-89

Location

Loc Qty

Loc Code

ST221

10

125472

5

125702

5

**

DAS

6

9-89

DAS

28

9-89

D4716-3

Manufactured No

110 Each

16.0000

4

4

D4716-3

Duct Hose

DAS
27
9-89

Location

Loc Qty

Loc Code

ST221A

16

125473

12

125703

4

**

DAS

6

9-89

DAS

28

9-89

DEC 02 2015

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**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 5

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D4716-5 Manufactured No

110 Each 30.0000 6 6

D4716-5

Duct Hose

DAS
27
9-89

Location

Loc Qty

Loc Code

ST221b

30

125474

13

125704

17

6

DAS
28
9-89

D4728-057 Manufactured No

110 Each 22.0000 1 1

D4728-057

Ps7J1 Jumper

DAS
27
9-89

Location

Loc Qty

Loc Code

MF

7

117935

7

MF5

15

124738

15

7

DAS
28
9-89

D4728-063 Manufactured No

110 Each 22.0000 1 1

D4728-063

Cabin Temp Sensor Jumper Assembly

DAS
27
9-89

Location

Loc Qty

Loc Code

MF5

22

117938

7

124750

15

7

DAS
28
9-89

D4730-020-035 Manufactured No

110 Each 14.0000 24 24

D4730-020-035

Velcro Strip 2.0W/ X 3.5L

DAS
27
9-89

Location

Loc Qty

Loc Code

ST410

14

125419

14

130057

DAS
28
9-89
DEC 02 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 6

Friday, January 30, 2015 11:01:17 AM

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

D5032-1 Manufactured No

110 Each 47.0000 16 16

D5032-1

Doubler

BAS
27
9-89

Location

Loc Qty

Loc Code

ST143

47

125200

7

126462

40

**

DAS
8
9-89

DAS
28
9-89

D5032-3 Manufactured No

110 Each 53.0000 16 16

D5032-3

Doubler

BAS
27
9-89

Location

Loc Qty

Loc Code

ST143

53

125108

13

126463

40

**

DAS
6
9-89

DAS
28
9-89

2351-20-21-C3C Purchased No

110 Each 175.0000 16 16

2351-20-21-C3C

STUD

BAS
27
9-89

Location

Loc Qty

Loc Code

MF4

103

M128068

103

ST569

72

m130595

72

**

DAS
6
9-89
DEC 02 2015

DAS
28
9-89

50-009-2 Purchased No

100 Each 81.0000 16 16

50-009-2

Grommet

BAS
27
9-89

Location

Loc Qty

Loc Code

MF4

77

m128047

77

ST562

4

m128047

4

**

DEC 02 2015

DAS
6
9-89

Friday, January 30, 2015 11:01:17 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 30, 2015 11:01:17 AM

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

AN970-3 Purchased No 110 Each 306.0000 10 10

AN970-3

Washers

DAS 28
6 28
9-89 9-89

Location Loc Qty Loc Code

ST325A 200
m129630 200
ST329 106
m128057 106

DAS 27
9-89

BT1.5I-M Purchased No 110 Each 1,034.000 24 24

BT1 5I-M

Tie Wrap

Location Loc Qty Loc Code

CCK003 1032
m128238 1032
st552 2
m123742 2

DAS 27
9-89

DAS 28
6 28
9-89 9-89

BT3LH-L Purchased No 110 Each 200.0000 12 12

***BT3I H-I ***

Tie Wrap

Location Loc Qty Loc Code

CCK003 168
m128238 168
st552 32
m128238 32

DAS 27
9-89

DAS 28
6 28
9-89 9-89

DEC 02 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Page 8

Friday, January 30, 2015 11:01:18 AM

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,445.000

35

35

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

1000

M131317

1000

ST305

1022

M130799

5

M131264

1017

ST307

3

123900

3

BAS
27
9-89

DAS
6
9-89
DAS
28
9-89

MS24694-S51

Purchased

No

110

Each

288.0000

36

36

MS24694-S51

Screw

Location

Loc Qty

Loc Code

ST289

288

m130928

288

BAS
27
9-89

DAS
6
9-89

MS27039-1-15

Purchased

No

110

Each

173.0000

21

21

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

GA

99

m127916

99

ST285

74

m127916

74

BAS
27
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DEC 02 2015

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Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 9

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0316J

Purchased

No

110

Each

576.0000

5

5

NAS1149D0316.I

Washer

Location

Loc Qty

Loc Code

ST270

576

122151

188

M127956

388

**

DAS

28

9-89

DAS

28

9-89

BAS

27

9-89

NAS1149D0332J

Purchased

No

110

Each

1,658.0000

34

34

NAS1149D0332.I

Washer

Location

Loc Qty

Loc Code

CA

14

m129682

14

ST269

1644

m130325

1644

**

DAS

28

9-89

DAS

28

9-89

BAS

27

9-89

NAS1149D0663J

Purchased

No

110

Each

287.0000

6

6

NAS1149D0663.I

Washer

Location

Loc Qty

Loc Code

ST269

287

M126334

287

**

DAS

28

9-89

DAS

28

9-89

BAS

27

9-89

CB200

Purchased

No

110

Each

30.0000

3

3

CB200

Acrylic Adhesive, 3.5G

Location

Loc Qty

Loc Code

CA2

30

129452

13

130685

17

**

DAS

28

9-89

DAS

28

9-89

BAS

27

9-89

DEC 17 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
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Handling/Pre									
Material									
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---	--

Picklist Print

Page 10

Friday, January 30, 2015 11:01:18 AM

Work Order ID: 129190

129190

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 1/30/2015

Required Date: 1/30/2015

Start Qty: 1.00

Required Qty: 1.00

CS125-1032-8AACR

Purchased

No

110

Each

56.0000

2

2

CS125-1032-8AACR

Stud

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST548

56

M130277

56

2

D5078-1

Manufactured

No

110

Each

8.0000

1

1

D5078-1

Bracket

DAS
6 28
9-89

Location

Loc Qty

Loc Code

ST145

8

125455

8

7

DAS
27
9-89

DEC 22 2015

Friday, January 30, 2015 11:01:18 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
--	--	---

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accomodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

129190 NLS
1501-30

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
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DART SERVICE INSTRUCTION

**TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT**

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

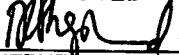
5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.

QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO #01-O-01

APPROVED

BY: 
D. SHEPHERD (DE #02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET INSTALLATION	NTS
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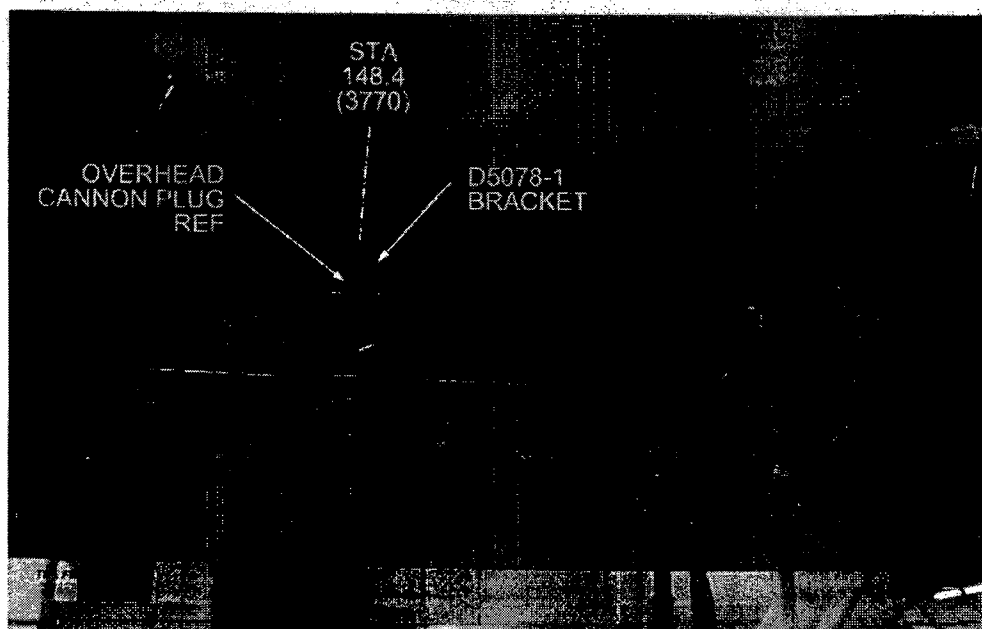


Figure 1. - LH Side Overhead Panel

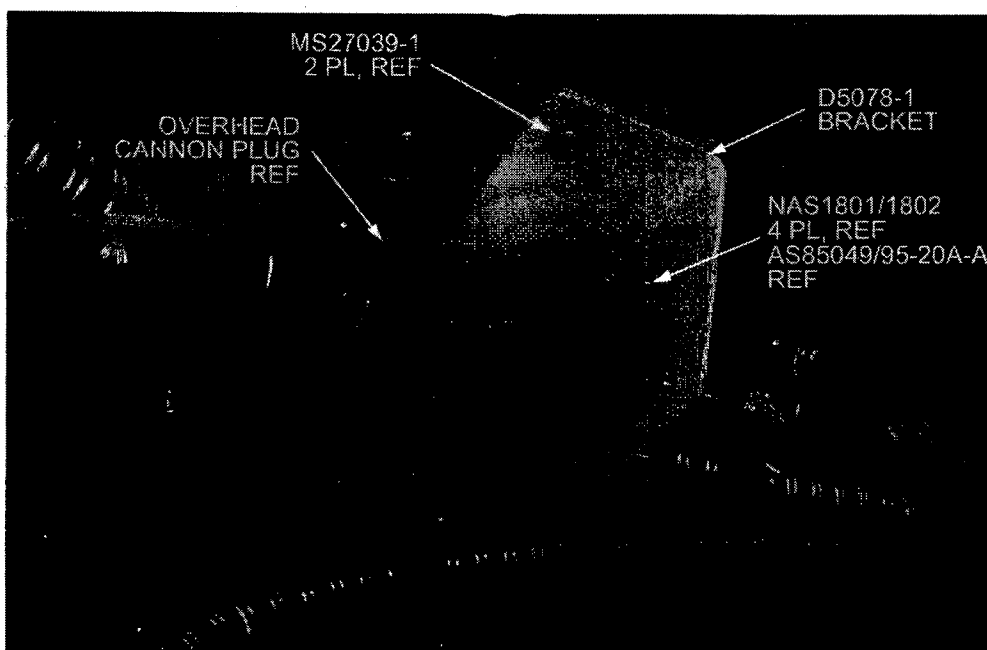


Figure 2. - D5078-1 Bracket Installation

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. DSI 9691	REV. A
MFG. APPR.	N/A		SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET INSTALLATION	NTS
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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

REFERENCE ONLY

DAS

27

8-89

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
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- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accomodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.

QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
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DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54
REF. FAA STC: SR03251NY
REF. EASA STC: 10045158

BAG
27

REFERENCE ONLY

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
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This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

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QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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5.0 PARTS LIST

REFERENCE ONLY

BAS
27
8-89

Qty -011	Part Number	Description
X	D139-816-011	INTERIOR CEILING PANEL KIT
1	D4634-041	FWD, CENTER CEILING PANEL ASSEMBLY
1	D4634-141	* FWD, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-043	MIDDLE, CENTER CEILING PANEL ASSEMBLY
1	D4634-143	* MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4634-045	AFT, CENTER CEILING PANEL ASSEMBLY
1	D4634-145	* AFT, CENTER CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-041	LH, FWD CEILING PANEL ASSEMBLY
1	D4635-141	* LH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-042	RH, FWD CEILING PANEL ASSEMBLY
1	D4635-142	* RH, FWD CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-043	LH, AFT CEILING PANEL ASSEMBLY
1	D4635-143	* LH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
1	D4635-044	RH, AFT CEILING PANEL ASSEMBLY
1	D4635-144	* RH, AFT CEILING REPLACEMENT PANEL ASSEMBLY
16	D4636-043	RECEPTACLE BRACKET ASSEMBLY
10	D4636-11	BRACKET
16	D4636-5	BRACKET
4	D4636-7	RETAINER PLATE
1	D4636-9	TEMPLATE
1	D4648-1	TEMPLATE
6	D4653-041	VENT MANIFOLD ASSEMBLY
6	D4653-11	CLAMP
3	D4664-7	SPACER
2	D4712-043	BRACKET ASSEMBLY
2	D4716-1	DUCT HOSE
4	D4716-3	DUCT HOSE
6	D4716-5	DUCT HOSE
1	D4728-057	HARNESS ASSEMBLY
1	D4728-063	HARNESS ASSEMBLY
24	D4730-020-035	VELCRO STRIP
16	D5032-1	DOUBLER
16	D5032-3	DOUBLER
16	2351-20-21-C3C	DZUS SCREW
16	50-009-2	GROMMET
10	AN970-3	WASHER
24	BT1.5I-M	TIE WRAP
12	BT3LH-L	TIE WRAP
1	CB 200	3.5g ACRYLIC ADHESIVE
2	CS125-1032-8-AA-CR	STUD (or CS125-1032-8-AA-CRM)
35	MS21042L3	NUT
36	MS24694-S51	SCREW
21	MS27039-1-15	SCREW
5	NAS1149D0316J	WASHER (or AN960JD10L)
34	NAS1149D0332J	WASHER (or AN960JD10)
6	NAS1149D0663J	WASHER (or AN960JD616)

NOTES: (*) DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE
D4634-141/-143/-145 ARE REPLACEMENT PANELS
D4635-141/-142/-143/-144 ARE REPLACEMENT PANELS

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Revision: D
Date: 13.12.16

Work Order ID 129190

Friday, January 30, 2015 11:01:11 AM

129190

Page 1

Item ID: D139-816-011 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lightweight Interior Ceiling Panel
Start Date: 1/30/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 1/30/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 1501-30 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9686	A								
DSI9691	A								
IIN-D139-816	D								

100 Document Control 0.00
100 DOCUMENT CONTROL
DC Memo 0.00
Doc.Control -USB or Paperwork Photocopy blue file & type labels as per PPP D139-816-011 CH005
see at Hkment MLJ

MLJ DEC 02 2015

110 Pick Kit 0.00
110
Packaging Memo 0.00
Packaging

NOV 30 2015

PAGE 1 OF 1

Part Number: D139-816-011

Description: INTERIOR CEILING PANEL

[illegible]

A